



Dart Aerospace Ltd.
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RBE350A94-3700-A-1A

Job Sheet 181131



DAG
21
2-00

Part No: RBE350A94-3700-A-1A

Job Qty: ~~24~~ pcs **18**

Part Name: Long Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/18

Job Tracking No:

Due Date: 9/24/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	24 pcs	9/24/18	9/24/18	0.00	2.40	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	24 pcs	9/24/18	9/24/18	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	24 pcs	9/24/18	9/24/18	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

DAG
21
2-00

19/02/28



Container No: S157698



Part: RBE350A94-3700-A-1A

Job No: 181131

Serial No/Batch: S157698

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 02/28/19

					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	MLC
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	24 pcs	9/24/18	0.00 0.00	QC 21 - SA - 21	QC 21 - SA - 70	DAS
						21 FEB 28 2019 GA

Part Op 110 - Small Fab-3 (Small Fab) - Assemble as per DWG. Sheet 2 - Loctite 262 R 5157322 Exp: 07/01/2020 - See Descriptions: note 1

- 120 - QC5 (QC5- Inspect part completeness to step on W/O)
 130 - Packaging3-1 (Identify as per dwg & Stock Location: _____)
 140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	36 48 Ea (2 ea)	110-Small Fab - 1	5122137
92905A225	Extended Point Set Screw, Dog Point	18 24 Ea (1 ea)	110-Small Fab - 1	5126987
CL-2-C	Lanyard Wire	31.2000 ft (1.3 ea)	110-Small Fab - 1	5119833
NAS1756-12	Remove Before Flight	24 Ea (1 ea)	110-Small Fab - 1	5134216
RBE350A94-3700-A-01	Tube	24 pcs (1 ea)	110-Small Fab - 1	5136777
RBE350A94-3700-A-03	Top	24 pcs (1 ea)	110-Small Fab - 1	10X5146074 8X 5104869
RBE350A94-3700-A-05	Foot	24 pcs (1 ea)	110-Small Fab - 1	5147469

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3896T31	48	614	0
	92905A225	24	72	0
	CL-2-C	31	492	0
	NAS1756-12	24	486	0
	RBE350A94-3700-A-01	24	31	0
	RBE350A94-3700-A-03	24	45	0
	RBE350A94-3700-A-05	24	52	0

Part Specifications
Specifications could not be found.

Plex 1/24/19 2:11 PM Dart.Hadley.Shannon



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RBE350A94-3700-A-1A

Job Sheet 181131



Part No: RBE350A94-3700-A-1A

Job Qty: 12 ea

Part Name: Long Brace Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/22/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		8/20/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	12 pcs		8/20/18	0.00	1.20	Small Fab-3		
120	QC	12 pcs		8/20/18	0.00	0.00	QC5		
130	Packaging	12 pcs		8/20/18	0.00	0.00	Packaging3-1		
140	QC21-SA	12 Ea		8/20/18	0.00	0.00	QC21		

Part Op Descriptions: **110** - -Assemble as per DWG. Sheet 2 -Loctite 262 B _____ Exp: _____ -See note 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	24 Ea (2 ea)	90-Start up Operation	5109072
92905A225	Extended Point Set Screw, Dog Point	12 Ea (1 ea)	90-Start up Operation	5098332
CL-2-C	Lanyard Wire	15.6000 ft (1.3 ea)	90-Start up Operation	5098332
NAS1756-12	Remove Before Flight	12 Ea (1 ea)	90-Start up Operation	5098332
RBE350A94-3700-A-01	Tube	12 Ea (1 ea)	90-Start up Operation	5105541
RBE350A94-3700-A-03	Top	12 Ea (1 ea)	90-Start up Operation	5104811
RBE350A94-3700-A-05	Foot	12 Ea (1 ea)	90-Start up Operation	5080303

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	24	1,097	0
	92905A225	12	64	0
	CL-2-C	16	471	0
	NAS1756-12	12	642	0
	RBE350A94-3700-A-01	12	7	0
	RBE350A94-3700-A-03	12	4	0
	RBE350A94-3700-A-05	12	25	0

Part Specifications

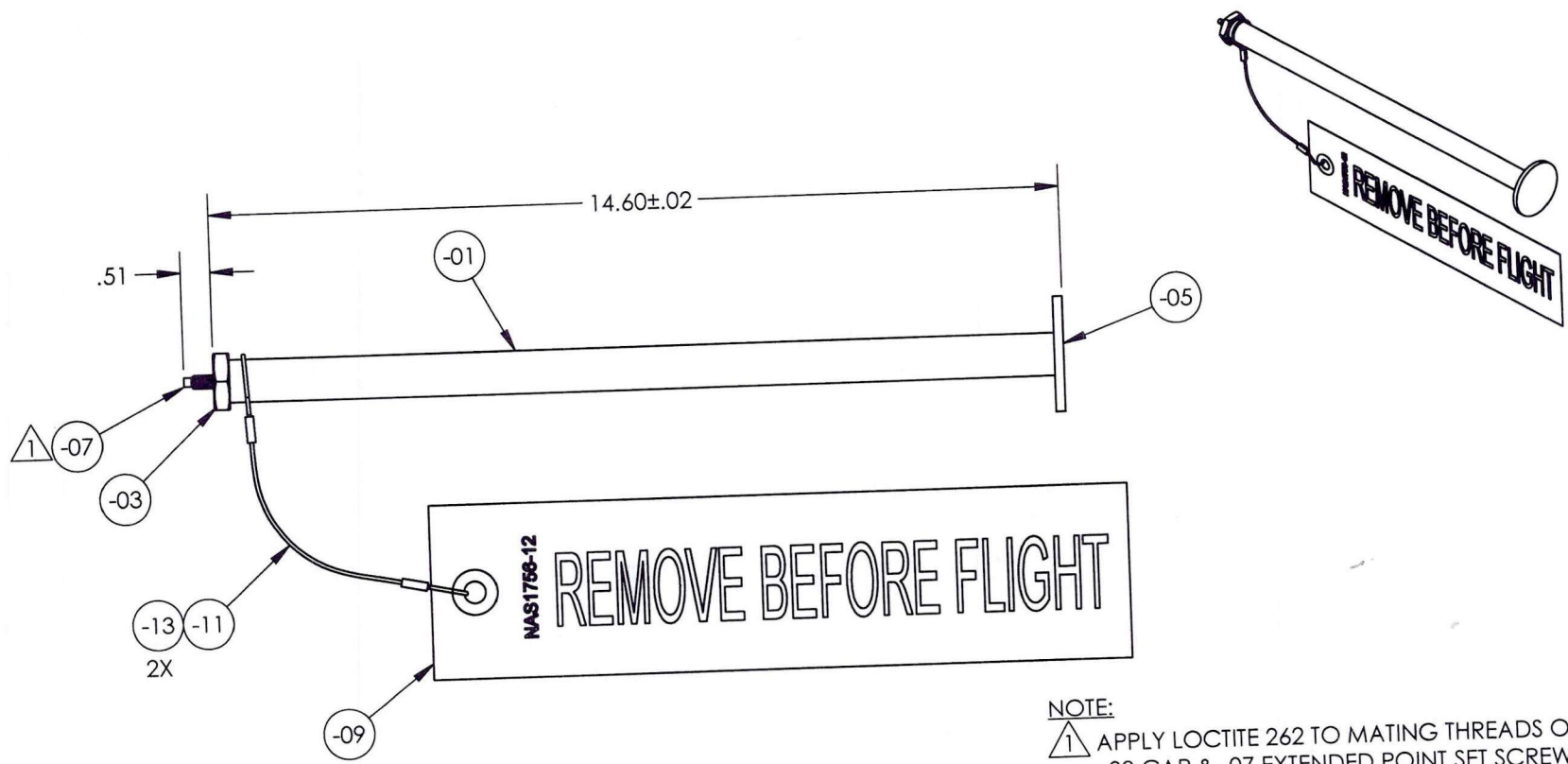
Specifications could not be found.

Plex 7/23/18 12:45 PM dart.logan.david

173916 @ 14418; 1751

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
7	16-0282	-1A ADDED TO BOM QTY: 3. ADDED DRAWING.	1/3/2017	DPD	JAG



NOTE:
 1 APPLY LOCTITE 262 TO MATING THREADS OF
 -03 CAP & -07 EXTENDED POINT SET SCREW,
 DOG POINT.

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-1A	REV 7
MAT'L	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES
	.015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY
CHECKED: MACKOVJAK	AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:3	DATE 8/21/2012
	SHEET 2 OF 5

(-1A)
 LONG BRACE ASSEMBLY

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					